



## Processing Conditions

### Acetal (POM) — RTP 800 Series Specialty Compounds

#### Typical Injection Molding Conditions

	English	SI Metric
<b>Temperatures</b>		
Rear zone	350 - 390 °F	177 - 199 °C
Center zone	360 - 400 °F	182 - 204 °C
Front zone	370 - 410 °F	188 - 210 °C
Melt	360 - 425 °F	182 - 218 °C
Mold	175 - 225 °F	79 - 107 °C

<b>Pressures</b>		
Injection	10000 - 15000 psi	69 - 103 MPa
Hold	5000 - 12000 psi	34 - 83 MPa
Back	50 - 100 psi	0.34 - 0.69 MPa

<b>Speeds</b>		
Fill	1 - 2 in/sec	25 - 51 mm/sec
Screw	60 - 90 rpm	60 - 90 rpm

<b>Drying</b>		
Time & Temperature	2 Hrs @ 250 °F	2 Hrs @ 121 °C
Dew Point	-25 °F	-32 °C
Moisture Content	0.15 %	0.15 %

#### Notes

- This information is intended to be used only as a guideline for designers and processors of modified thermoplastics for injection molding. Because injection mold design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.
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